

Date: Tuesday, 23/12/2008 12:53:38 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	PEDAL LOCK BASE
Job Number :	44288		
Estimate Number :	11361		
P.O. Number :		Part Number :	D33703
This Issue :	23/12/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3370 REV C
First Issue :	/ /	Project Number :	N/A
Previous Run :	37187	Drawing Revision :	C
	Type :	Material :	
	MACHINED PARTS	Due Date :	20/01/2009
Written By :		Qty:	4
Checked & Approved By :		Um:	Each
Comment :	Est. B 05.05.25 Added Powder Coat KJ/JLM Est Rev:C 08-07-17 revC as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X02500	6061-T6 Bar 1.50 x 2.50
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Comment: Qty.: 0.3657 f(s)/Unit Total : 1.4629 f(s)
 6061-T6 Bar 1.5" x 2.5"
 Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8)
 (M6061T6B1.500x02.500)
 Identify for D3370-3
 Batch: M10974

ml 09/01/05

45

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blank: 1.500" x 2.500" x 4.120" long

ml 09/01/05

45

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine D3370-3 as per Folio FA482 and Dwg D3370
 Identify as D3370-3
 Dwg Rev: C

J.F. 09/01/06

(4)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 09/01/06

(4)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JL 09/01/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3370-3 PAR #: N/A Fault Category: Prod/Machined Part NCR: Yes ~~No~~ DQA: D Date: 09/01/13
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: D Date: 09/01/13

NCR: <u>44288</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/01/06	3.0	1 part is scrap. Part came out of vice during machining. R.C: Feed was too fast & pulled up the part R.C: Process		I put the Feed at 50% for the Broughing. B. After all the affected parts, and continue machining. Part is acceptable with no more problems.	J.F. 09/01/06			

NOTE: Date & initial all entries

Date: Tuesday, 23/12/2008 12:53:38 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL LOCK BASE

Job Number: 44288

Part Number: D33703

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(4)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 09/01/08

7.0

POWDER COATING

POWDER COATING



M18052



(4X)

Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:00
320°F
3:30

MF 09/01/09

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Q.N 09/01/09

(4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(4X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 485

9/1/12

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/12

Job Completion



MF 09-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	44287
Description: Pedal Lock Cover		Part Number:	D3370-3
Inspection Dwg: D3370	Rev: B	Page 1 of 1	

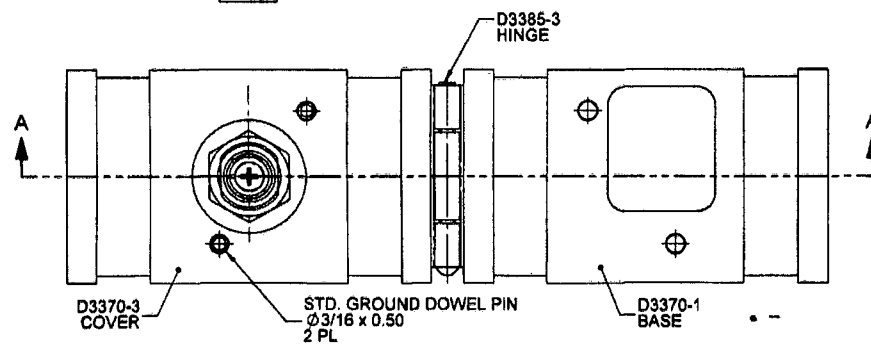
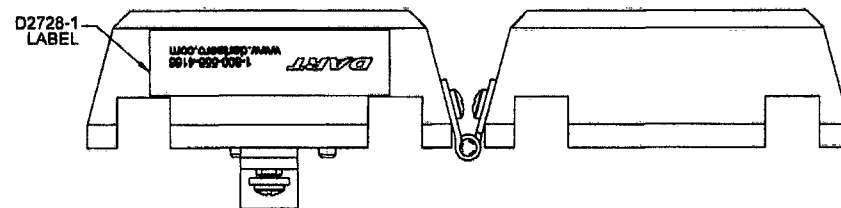
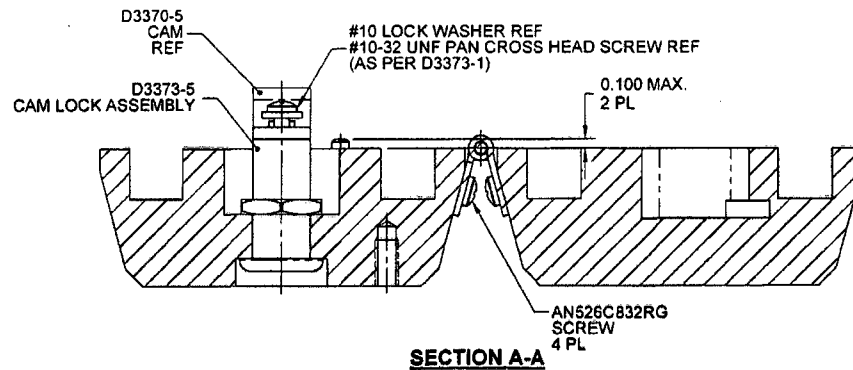
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	+/-0.030	4.003"	✓			
3.344	+/-0.010	3.340"	✓			
0.592	+/-0.010	.589"	✓			
0.202	+/-0.010	.212"	✓			
Ø1.000	+0.005/-0.000	Ø1.003"	✓			
0.25	+/-0.030	.230"	✓			
0.283	+/-0.010					
2.000	+/-0.010	2.010"	✓			
0.300	+/-0.010	.302"	✓			
0.550	+/-0.010	.550"	✓			
1.50	+/-0.030	1.499"	✓			
Ø1.250	+0.005/-0.000	Ø1.250"	✓			
0.635	+/-0.010	.635"	✓			
Ø0.750	+0.010/-0.000	Ø.758"	✓			
1.673	+/-0.010	1.672"	✓			
0.430	+/-0.010	.430"	✓			
2.638	+/-0.010	2.638"	✓			
2.35	+/-0.030	2.360"	✓			
0.715 deep	+/-0.010	.715"	✓			
15°	+/-0.1°	15°	✓			
0.19 x 45°	+/-0.030	.190"	✓			
0.450	+/-0.010	.454"	✓			
1.450	+/-0.005	1.450"				

Measured by: J.F.	Audited by: J.L.	Prototype Approval:	N/A
Date: 09/01/06	Date: 09/01/07	Date:	N/A

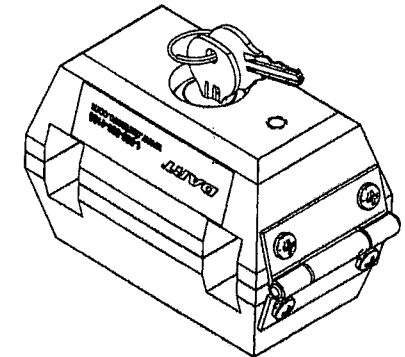
Rev	Date	Change	Revised by	Approved
A	05.01.05	New Issue	KJ/JLM	
B	05.04.26	Revised dimensions	KJ/JLM	
C	05.05.25	Revised dimensions	KJ/JLM	



D3370-051 PEDAL LOCK ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.75 lbs

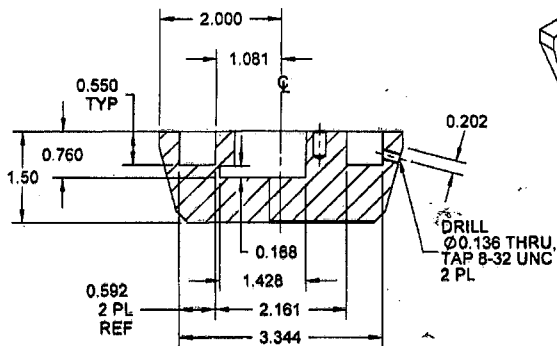
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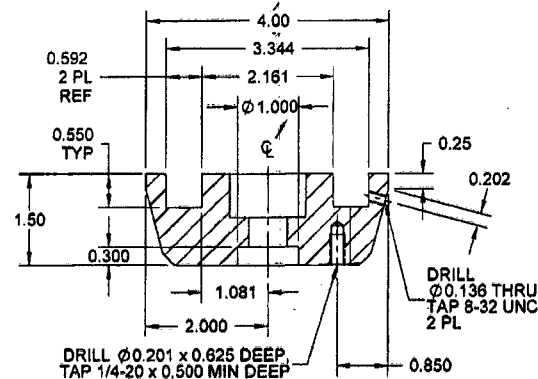
RELEASED
08-07-11

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3370	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		PEDAL LOCK	NTS
DATE	08.07.11	COPY RIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

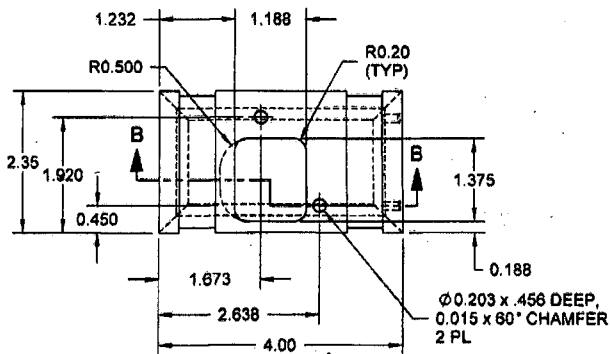
u/o 44288



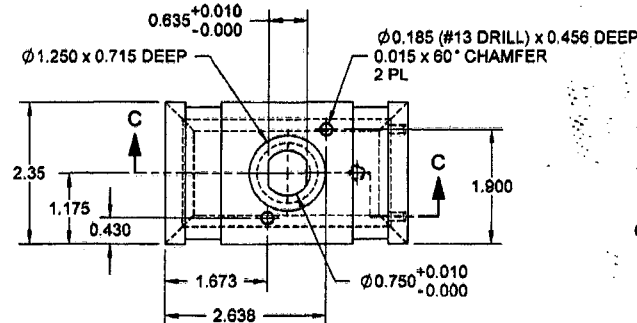
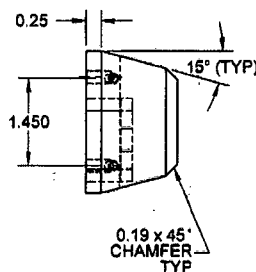
SECTION B-B



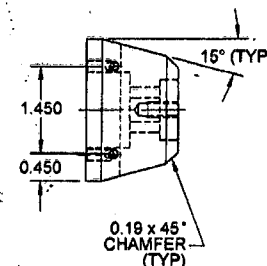
SECTION C-C



D3370-1 BASE



D3370-3 COVER



NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) REF. DART SPEC. M6061T6B
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED
08-07-16

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3370	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		PEDAL LOCK	NTS
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8 7 6 5 4 3 2 1

△

Qty. -041	Qty. -051	PART NUMBER	DESCRIPTION
X		D3370-041	TAIL ROTOR DISABLING KIT
1	X	D3370-051	PEDAL LOCK
1		D3384-041	CYCLIC SOCK
1		HX-81	1/4-20 SOCKET HEAD CAP SCREW
2		AN960-418	WASHER
1		D2728-7	LABEL
1		D3370-1	BASE
1		D3370-3	COVER
1		D3373-5	CAM LOCK ASSY
1		D3385-3	HINGE
2		Ø 3/16 X 0.50 GROUND STUD DOWEL PIN	GROUND STUD DOWEL PIN
4		AN526C832R6	SCREW

Mo 44288

RELEASED
08.07.11

C	SHEET 1 ADDED P/L, ADDED -041 TO P/L (SEE NCR 284). DRAWING TRANSFERRED TO "B" SIZE FORMAT. REFORMATTED TO CURRENT STANDARDS.		AJS	08.07.11
B	D3385-3 WAS D3385-1		MB	05.03.22
A	NEW ISSUE		RF	04.12.15
REV.	DESCRIPTION		BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. C	
MFG. APPR.		D3370	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		PEDAL LOCK	NTS	
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8 7 6 5 4 3 2 1